

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021713**Date Inspected:** 06-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 14

This QA Inspector randomly observed the following work in progress in the Bay 14:

SMAW welding of weld joint SA3231B-001 located on PCMK OBG 13BW. Welder was identified as 066398. QC was identified as ZPMC QC Ji Cai Feng (QC1), who was not a CWI. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ABF QC Chen Kun (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2212-TC-U4b-FCM-1 as verbally identified by QCA1.

SMAW welding of weld joints DP3166-001-001, 002, 003 located on PCMK OBG 14E. Welder was identified as 043661. QC was identified as ABF CWI Bao Qian (QC2), who was not a CWI. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was ABF QC Zhong Yong Gang (QCA2), who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2112-FCM-1 and WPS-B-P-2113-FCM-1 as verbally identified by QC2.

FCAW welding of weld joints DP3167-001-148~151 located on PCMK OBG 14E. Welder was identified as 044790. QC was identified as QC2, who was not a CWI. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by

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QCA2 appeared to comply with WPS-B-T-2133-ESAB and WPS-B-T-2233-ESAB as verbally identified by QC2. See photo of completed welds below.

FCAW welding of weld joints SA3174-001-041 located on PCMK OBG 13AW. Welder was identified as 045175.

QC was identified as QC1, who was not a CWI. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QC2.

FCAW welding of weld joints DP3173-001-193, 194, 196, 197 located on PCMK OBG 14W. Welder was identified as 207465. QC was identified as QC1, who was not a CWI. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Li Ping QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-2132-ESAB and WPS-B-T-2232-ESAB as verbally identified by QC2. See photo of welder preheating the base metal at weld joints DP3173-001-196 and 197 prior to welding below.

FCAW welding of weld joint SEG3020AJ-249 located on PCMK OBG 14W. Welder was identified as 067040. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA3.

FCAW welding of weld joint SEG3013Y-424 located on PCMK OBG 13AW. Welder was identified as 068445. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QCA3.

FCAW welding of weld joint SEG3013Y-356 located on PCMK OBG 13AW. Welder was identified as 067876. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QCA3.

FCAW welding of weld joint SEG3013AH-136 located on PCMK OBG 13AW. Welder was identified as 066421. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QCA3.

FCAW welding of weld joint SEG3013P-004 located on PCMK OBG 13AW. Welder was identified as 067876. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA3.

FCAW welding of weld joint SEG3013G-017 located on PCMK OBG 13AW. Welder was identified as 203871. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA3.

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SMAW welding of weld joint SEG3013AH-151 located on PCMK OBG 13AW. Welder was identified as 067764.

QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1 as verbally identified by QCA3.

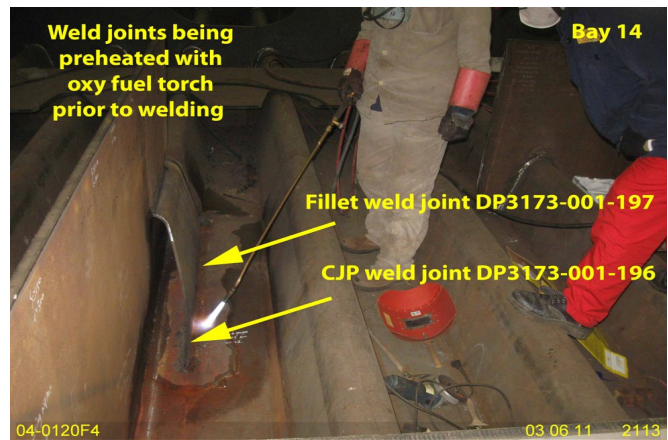
SMAW welding of weld joint SEG3013AH-013 located on PCMK OBG 13AW. Welder was identified as 066038.

QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1 as verbally identified by QCA3.

SMAW welding of weld joint DP3122-001-012 located on PCMK OBG 13AW. Welder was identified as 047864.

QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-P-2213-B-U2-FCM as verbally identified by QCA3.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Goulet, George

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer
